



A rounding type edge 40 is shown on the top of 15 and a similar radius 45 is shown at the bottom of strip 15. A female die 50 with a protruding lip 55 is producing this bottom rounding feature.

Fig. 3 is a mitered corner of a frame 60 with a clinched slug 25 in place in two slots 20.

A remnant 65, that is purposely left during mitering, holds the frame together

5 until clinching of slug 25 can be done.

Fig. 4 is a fabrication sequence of a frame 70 with a plurality of 45-degree cuts.

A remnant 65 is left in three places. Punched holes 20 is shown in one corner with a slug 25 shown inserted in another corner to achieve secure joining.